

Date: Tuesday, 27/05/2008 12:37:38 PM  
User: Linda Lacelle

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : INNER FWD SADDLE
<b>Job Number</b> : 39509	
<b>Estimate Number</b> : 11079	
<b>P.O. Number</b> :	<b>Part Number</b> : D5953
<b>This Issue</b> : 27/05/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D5953 REVB
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : B
<b>Previous Run</b> : 39197	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 03/06/2008 <b>Qty:</b> 2 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> :	
<b>Comment</b> : Est Rev:E Re-Format 05-11-29 JLM	
Est Rev:f ecn 826 06.12.06 EC	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D6101007	Saddle Billet
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)  
D6101-007(7075-T7351)  
Size 2.50" x 7.50" X 8.25" (Grain along 7.50")  
Batch: B34815

SP 08/05/31 (2)

2.0	HAAS3	HAAS CNC VERTICAL MACHINING #3
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**Comment:** HAAS CNC VERTICAL MACHINING #3

1-Machine as per folio D5953, Ensure Batch Number is entered

2-Machine Keyway

3-Deburr & Tumble

SP 08/05/31 (2)

3.0	QC1	INSPECT ALL DIM TO DIM SHEET
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**Comment:** INSPECT ALL DIM TO DIM SHEET

SP 08/05/31

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

SP 08/06/02

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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**Comment:** HAND FINISHING RESOURCE #1  
Chemical Conversion Coat as per QSI 005 4.1

M-f/SP 08/06/02 (2X)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/05/31	2.0	Dimension of .500" $\pm$ .010" of The center hole .438" was off by .008" under Tolerance.		<del>Parts are within</del> tol.	85 08/05/31			
		R.C. parts is making on jig because Dowel Pins is too small in Diameter. Goodbye						

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: INNER FWD SADDLE

Job Number: 39509

Part Number: D5953

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M107925



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

1:05

OVEN TEMPERATURE:

320°

FINISH TIME:

1:35

FL 08/06/02

(2)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BL 08-06-02

(2)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 421

8/6h

(2x)

SP

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/06/03 dg

Job Completion



u 08-06-03

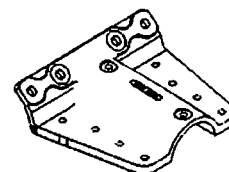
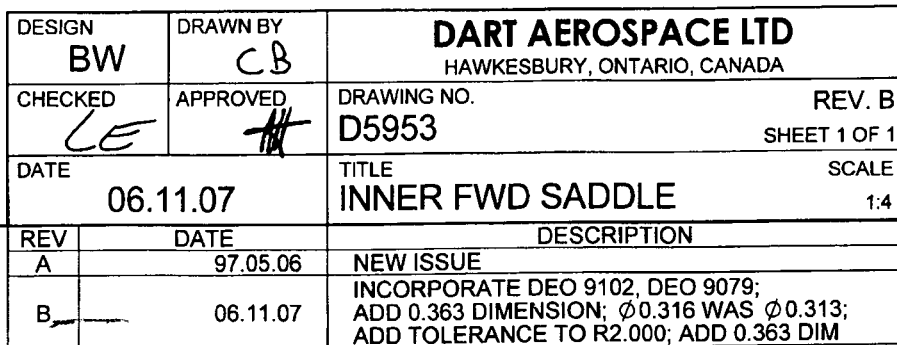
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 39509
<b>Description:</b> Inner Fwd Saddle		<b>Part Number:</b> D5953
<b>Inspection Dwg:</b> D5953	<b>Rev:</b> B	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.443	.443				
B	1.745	1.755		1.750	1.750				
C	5.245	5.255		5.250	5.250				
D	6.995	7.005		7.000	7.000				
E	5.240	5.260		5.250	5.250				
F	4.745	4.755		4.750	4.750				
G	0.315	0.322		.319	.319				
H	1.522	1.532		1.527	1.526				
I	3.048	3.058		3.052	3.051				
J	4.575	4.585		4.582	4.580				
K	0.313	0.318		.318	.318				
L	0.495	0.505		.501	.500				
M	0.490	0.510		.505	.499				
N	1.615	1.635		1.625	1.625				
O	7.990	8.010		7.992	7.999				
P	2.240	2.260		2.250	2.250				
Q	0.307	0.312		.310	.310				
R	0.760	0.765		.760	.760				
S	0.490	0.510		.482	.501				
T	1.375	1.395		1.385	1.385				
U	2.000	2.020		2.004	2.002				
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <i>RF</i>
Date: 08/08/31

Audited by: <i>RF</i>
Date: 08/06/02

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.12.06	Dimensions L,N,P revised	KJ/EC	
D	07.06.15	Dimension G revised	KJ/JLM	
E	08.04.21	Dimension E revised	KJ/DD	